Cont A1 cavity bounded by four rectangular side walls and a bottom wall, said foamed polymer body having an open top end, and

(ii) a flexible, un-foamed polymer bag, said flexible, un-foamed polymer bag having a generally uniform width over its length and being integrally bonded to said foamed polymer body along said rectangular prismatic cavity, said open top end and said four rectangular side walls; and

(c) an inner box, said inner box being slidably removably disposed within said insulated insert.

A2 10. (Amended) The insulated shipping container as claimed in claim 1 wherein said generally uniform width of said flexible, un-foamed polymer bag is sized to be approximately equal to the outer dimension of said foamed polymer bag.

A3 24. (Amended) An insulated shipping container made by a method comprising the steps of:

(a) providing a machine including

(i) a base portion with an internal cavity, an upper surface, and a source of vacuum connecting to said internal cavity;

(ii) a plug member disposed upon said upper surface;

(iii) a peripheral array of holes circumscribing said plug member and opening through said upper surface to said internal cavity of said base portion;

(iv) an array of cooperative wall members associated with said base portion, said wall members in a first position opening away from one another to leave said plug member exposed upon said base portion, said wall members closing together on said

cont A3

base portion to a second position in which said wall members engage one another and cooperatively define an enclosure surrounding said plug member in spaced relation thereto;

(v) said cooperative wall members each having a respective top edge spaced from said base portion, and a lid member 94 cooperating with said wall members to substantially close said enclosure;

(b) providing a corrugated fiberboard box having an open end and a closed end;

(c) positioning said corrugated fiberboard box in an inverted manner over said plug member with said closed end of said corrugated fiberboard box in contact with the top of said plug member;

(d) providing an elongated plastic bag having an open end, a closed end and a generally uniform width over its length;

new

(e) positioning said elongated plastic bag over said corrugated fiberboard box in an inverted manner, with said closed end of said elongated plastic bag in contact with the closed end of said corrugated fiberboard box, and drawing the remainder of said elongated plastic bag over the top of the base member and the inside surfaces of the cooperative wall members, with the open end of said elongated plastic bag inverted over the top edges of the cooperative wall members, thus creating an annular recess around said corrugated cardboard box;

(f) tearing said elongated plastic bag around its perimeter at a location covering said corrugated fiberboard box;

Cont A3

(g) removing the closed portion of the torn elongated plastic bag;

(h) securing the remainder of the torn elongated plastic bag to the corrugated fiberboard box;

(i) injecting foaming polymer material into said annular recess;

(j) closing said annular recess with a lid while allowing said foaming polymer material to foam; and

(k) allowing said foaming polymer material to cure.

Please add the following new claims 25-26:

A4

25. (New) An insulated shipping container made by a method comprising the steps of:

(a) providing a machine including

(i) a base portion with an internal cavity, an upper surface, and a source of vacuum connecting to said internal cavity;

(ii) a plug member disposed upon said upper surface;

(iii) a peripheral array of holes circumscribing said plug member and opening through said upper surface to said internal cavity of said base portion;

(iv) an array of cooperative wall members associated with said base portion, said wall members in a first position opening away from one another to leave said plug member exposed upon said base portion, said wall members closing together on said base portion to a second position in which said wall members engage one another and cooperatively define an enclosure surrounding said plug member in spaced relation thereto;

Cont A1

(v) said cooperative wall members each having a respective top edge spaced from said base portion, and a lid member cooperating with said wall members to substantially close said enclosure;

(b) providing a corrugated fiberboard box having an open end and a closed end;

(c) positioning said corrugated fiberboard box in an inverted manner over said plug member with said closed end of said corrugated fiberboard box in contact with the top of said plug member;

(d) providing an elongated plastic bag having an open end, a closed end and a generally uniform width over its length, said generally uniform width being sized to be approximately equal to the outer dimension of said enclosure surrounding said plug member;

(e) positioning said elongated plastic bag over said corrugated fiberboard box in an inverted manner, with said closed end of said elongated plastic bag in contact with the closed end of said corrugated fiberboard box, and drawing the remainder of said elongated plastic bag over the top of the base member and the inside surfaces of the cooperative wall members, with the open end of said elongated plastic bag inverted over the top edges of the cooperative wall members, thus creating an annular recess around said corrugated cardboard box;

(f) injecting foaming polymer material into said annular recess;

(g) closing said annular recess with a lid while allowing said foaming polymer material to foam; and